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D3319-1
Job Sheet 187827



Part No: D3319-1

Job Qty: 14 ea

Part Name: Forward Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev:C Now on Waterjet 06-10-26 JLM IPP REV:D
17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs	1/11/19	1/11/19	0.00	1.25	Waterjet - Flow		AC 18/12/20
110	QC	12 pcs	1/11/19	1/11/19	0.00	0.00	QC2 Waterjet-2		AC 18/12/20 DAS
120	QC	12 pcs	1/11/19	1/11/19	0.00	0.00	QC8-2		DEC 31 2018 68
140	Brake NC	12 pcs	1/11/19	1/11/19	0.07	0.87	Brake NC 1		DAS 9-89
150	QC	12 pcs	1/11/19	1/11/19	0.00	0.00	QC5		38
160	Autoweld 1	12 pcs	1/11/19	1/11/19	0.00	3.08	Automated welding		IDE
170	QC	12 pcs	1/11/19	1/11/19	0.00	0.00	QC10		17
180	QC	12 pcs	1/11/19	1/11/19	0.00	0.00	QC5		17
190	SprayPaint	12 pcs	1/11/19	1/11/19	0.00	0.28	Spray Paint		AR 19-1-8 DAS
200	QC	12 pcs	1/11/19	1/11/19	0.00	0.00	QC3		JAN 10 2019 68
210	Packaging	12 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-1		JAN 11 2019 9-89
220	QC21-SA	12 Ea	1/11/19	1/11/19	0.00	0.00	QC21		JAN 11 2019

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: 10 2-Deburr if necessary
Descriptions: 140 - 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: 138901 2- Form flat on press using DT8776 block
160 - 8259 HARDCOAT B: 138901
190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
BATCH: 5140628
210 - Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	7.5360 sf (.628 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	8	274	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	4.980inches $\pm$ 0.030	5.010		

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

			4.950
2	Wearplate	1.600inches $\pm$ 0.010	1.610 1.590
3	Wearplate	2.660inches $\pm$ 0.010	2.670 2.650
4	Wearplate	3.190inches $\pm$ 0.010	3.200 3.180
5	Wearplate	3.563inches $\pm$ 0.010	3.573 3.553
6	Wearplate	4.710inches $\pm$ 0.030	4.740 4.680
7	Wearplate	0.600inches $\pm$ 0.030	0.630 0.570
8	Wearplate	10.576inches $\pm$ 0.010	10.586 10.566
9	Wearplate	11.942inches $\pm$ 0.010	11.952 11.932
10	Wearplate	18.090inches $\pm$ 0.030	18.120 18.060
11	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315
12	Wearplate	0.546inches $\pm$ 0.010	0.556 0.536
13	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315
14	Wearplate	0.670inches $\pm$ 0.010	0.680 0.660
15	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189
16	Wearplate	3.815inches $\pm$ 0.010	3.825 3.805
17	Wearplate	16.100inches $\pm$ 0.010	16.110 16.090

Plex 12/17/18 12:55 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S139579

Part: D3319-1
Job No: 187827
Serial No/Batch: S139579

Revision: D
Inspector:
Exp Date:
Instructions: Various STC's

Date: 12/20/18

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Email: sales@dartaero.com
www.dartaerospace.com

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					